



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D2278

Job Sheet 202335



Part No: D2278

Job Qty: 20 pcs

Part Name: Step Leg



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/19

Job Tracking No:

Due Date: 11/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now 6061-T6 06-06-23 JLM IPP Rev C New flat pattern 08.01.11 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		11/4/19	0.01	2.24	Waterjet - Flow		JRB 10/31/19
110	QC 2	20 pcs		11/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S228803

Part: D2278

Job No: 202335

Serial No/Batch: S228803

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/31/19

120 QC 8	20 pcs	11/4/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 10/31/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	NOV 04 2019 DA 40
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Handfinish - 1-1 Chemical-B4B	20 pcs	11/4/19	0.00 0.53	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	NOV 06 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

140 QC 7	20 pcs	11/4/19	0.00 0.00	Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	DAS
				QC 7 - 59	58
				QC 7 - 60	6.2
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
QC 7 - 81					
QC 7 - 76					
QC 7 - 79					
150 Packaging 3-1 - Stock - B4B	20 pcs	11/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS
				Packaging 3 - 6 - B4B	5
				Packaging 3 - 7 - B4B	6.2
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Plex 10/24/19 3:11 PM	Dart.lajeunesse.marie

NOV 06 2019

NOV 06 2019

160 QC 21 - SA		20	11/4/19	0.00 0.00	Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	D63
					QC 21 - SA - 21	21
					QC 21 - SA - 70	70
					QC 21 - SA - 53	

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Part Op 100 - 1-Cut as per Dwg D2278
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Chemical Conversion Coat per QSI005 4.1)
 140 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Identify as per dwg & Stock Location: _____) LOCATION : GA D7F
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	19.6300 sf (.9815 ea)	100-Waterjet - Flow - 1	5227404

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	20	77	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Leg	0.354Inches ± 0.010	0.364 0.344	0.353	
2	Leg	0.354Inches ± 0.010	0.364 0.344	0.354	
3	Leg	16.460Inches ± 0.030	16.490 16.430	16.460	
4	Leg	0.128Inches + 0.005 - 0.000	0.133 0.128	0.129	
5	Leg	0.354Inches ± 0.030	0.384 0.324	Radius 0.354	
6	Leg	2.000Inches ± 0.030	2.030 1.970	2.002	
7	Leg	4.740Inches ± 0.030	4.770 4.710	4.740	
8	Leg	8.460Inches ± 0.030	8.490 8.430	8.460	
9	Leg	0.213Inches ± 0.010	0.223 0.203		
10	Leg	0.750Inches ± 0.010	0.760 0.740	0.751	
11	Leg	0.080Inches ± 0.010	0.090 0.070	thick	

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS																													
Part No. _____		Rework Scrap Use-as-is		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging																													
Date: _____		Sequence #: _____		QTY Affected: _____																													
Description Work Order Deviation		Disposition		MRRB (QS1042)																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"><tr><td>Pressure/Forced</td><td>Contamination</td><td>Power Loss/Surge</td><td>Positioned Wrong</td></tr><tr><td>Bending</td><td>Misaligned/off center</td><td>Folio/Program</td><td>Outside Tolerance</td></tr><tr><td>Crushing</td><td>BOM/Route</td><td>Grain Direction</td><td>Drawing</td></tr><tr><td>Cracks</td><td>Broken/Damage/Defect</td><td>Weld</td><td>Finish</td></tr><tr><td>Crimp/Kink/Ripple/Wave/Twist</td><td>Incomplete/Unclear Instructions</td><td>Wrong Stock Pulled</td><td>Part Lost/Missing</td></tr><tr><td>Marks/Chatter</td><td>Drill Holes</td><td>Out of Sequence</td><td>Misread</td></tr><tr><td>Mislabeled</td><td>Fit/Function</td><td>Off-set/Set-up</td><td></td></tr></table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
Other/Details: _____																																	
Completed By		Lead hand / Supervisor																															
QC / QA Coordinator																																	